

### Bonney's New Patent Machine Pipe and Drill Vise Combined.

The engravings herewith represent a rapid vise and attachments, and are representative of a variety of sizes and styles, including vises for jewelers, amateurs, machinists, railroad shops, coach makers, etc., now being manufactured and put on the market by the Bonney Rapid Vise Company, Marion, Ind., formerly of Philadelphia, Pa.

These vises have been designed and patented by Mr. C. S. Bonney, general manager of the company. An inspection of cut No. 1 will give an idea of the general appearance of these goods and also of some details of construction not common in vises of this class. Among other things to be noticed is the use of solid wrought steel sliding bars, on which the vises are cast, making a chilled bearing, and giving great strength and durability; also, it will be seen that instead of the common cam movement used in most rapid vises, which moves the jaws a short distance only at one adjustment, large steel screws are used which move the jaws in an ordinary vise  $1\frac{1}{2}$  inches with one adjustment. The manufacturers claim in these vises to have entirely overcome the slow motion of the ordinary screw vise, while retaining all its advantages in strength, power of grip and convenience of handling, in a most simple and efficient manner.

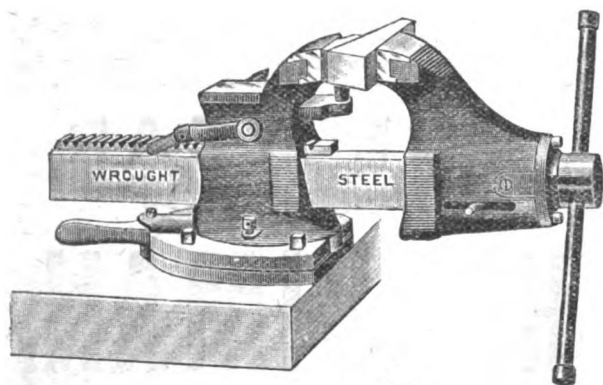
Having been actively engaged in making and selling vises for quite a number of years, during which time

ing a part of vise itself is a good feature, as there are no joints to wear and loosen.

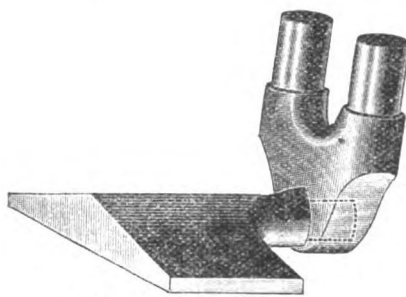
Cut No. 3 represents an entirely new device for covering the rough jaws when it is necessary to hold a smooth or finished article in vise. These jaws are made of malleable iron and faced with 3-16 soft brass. They fit firmly on jaws of vise, and the disagreeable way bent pieces have of falling on the floor when work is removed is gotten around. Nor will it tip when the work is near the top of jaw. Leather jaws, made in the same manner, but faced with leather, are furnished with the coach makers' or wood workers' vises.

Cut No. 4 represents the patent eccentric pipe grip, which, when inserted in the vise makes a rapid pipe vise and machinist's vise, one which on account of its construction is claimed to be the strongest pipe vise made. The patent eccentric pipe grip is guaranteed to absolutely never slip or crush the pipe. It embodies the same principle as that introduced into the pipe vises made by this concern, and soon will be illustrated in these columns.

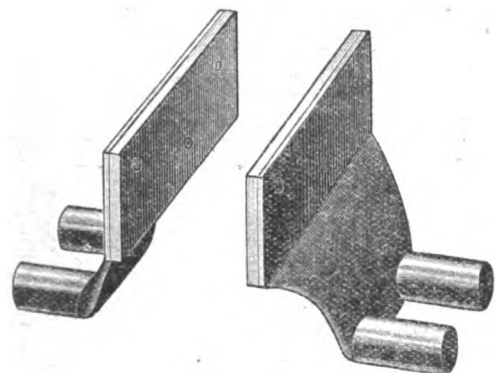
Cut No. 5 represents the detachable jaw for holding felloes. This, to a coach maker, is a very desirable article, as by its use he can hold the felloe of a wheel without marring it. The coach makers' vises made by this concern have very high jaws, and the vise is claimed to be of the very strongest, the solid steel sliding bar being of sufficient strength to stand up rigidly under any pressure.



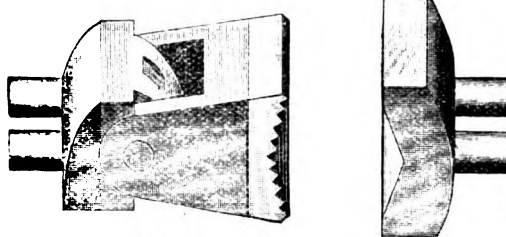
No. 1. BONNEY RAPID VISE.



No. 2. SWIVEL JAW.



No. 3. BRASS JAWS.

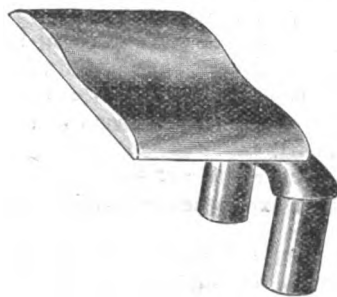


No. 4. PIPE GRIP.

they have been convinced of the need of a more perfect article than has heretofore been offered, they now confidently present a line of vises which they claim are superior in many respects to any heretofore made, for the following reasons: First, quick movement, and at the same time the firmness and power of grip of the ordinary screw vise; 2d, the screws are extra large size and have solid heads; 3d, anti-friction washer under head of screw; 4th, the nut is cut in solid steel bar and is extra long, being from  $4\frac{1}{2}$  to  $5\frac{1}{2}$  inches in length; 5th, sliding bar is of cold rolled wrought steel; 6th, steel handles extra size and length; 7th, the patent base is an improvement over all others and very convenient; 8th, the patent swivel jaw is self-adjusting, simple and good; 9th, the mortise in jaws instead of being chambered out as in other vises, is a perfect fit the whole length and hardened; 10th, each vise opens 2 inches further than other vises of same size, and is much stronger; 11th, the soft brass jaws are something entirely new—cannot fall off and never tip; 12th, the solid steel sliding bar being much narrower than the hollow cast iron bars used in other vises, give more space for holding work perpendicularly—a valuable advantage for heavy work; 13th, the prices are less than other first-class rapid vises.

Cut No. 2 represents the patent swing jaw or taper attachment, which, differing from others, is self-adjusting, and among the simplest and most convenient attachments for holding taper or irregular-shaped pieces; it is fitted to attach to either jaw and can be attached or removed instantly when desired. Not be-

The company, like all reputable concerns nowadays that are hustling for trade, guarantee their goods in every way and as represented; and if, when they are tried, they are found for any reason unsatisfactory,

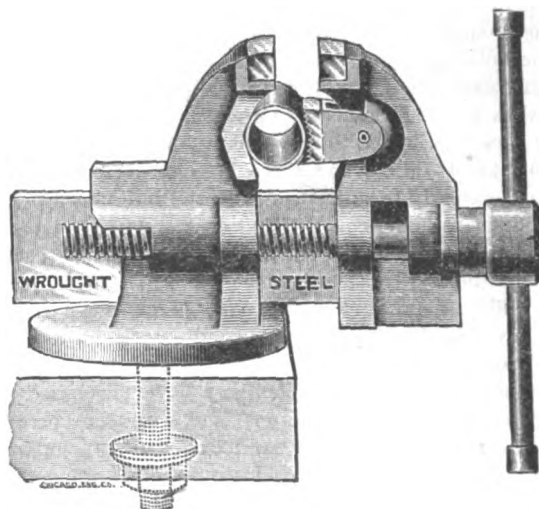


No. 5. FELLOE JAW.

they may be returned at their expense. Prices and catalogues will be furnished on application.

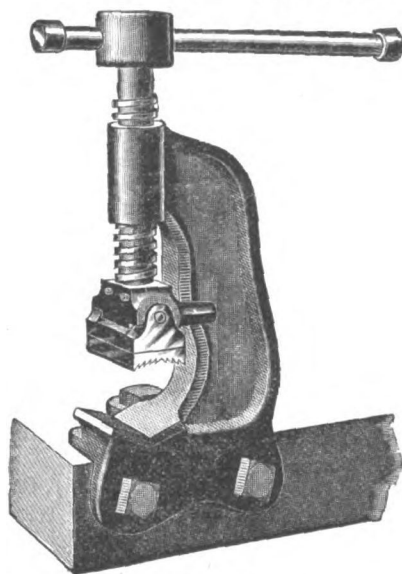
**Bonney Patent Pipe Vises.**

We illustrate in this connection Bonney's late improved patent pipe vises. These vises are made by the Bonney Rapid Vise Company, of Marion, Ind., and are called the "Never Slip," on account of the impossibility to turn anything placed in the vise in either direction after the patent jaw or grip once comes in contact with it. They are manufactured as a combination bench and pipe vise, and also in the form of a light, all-steel, open pipe vise for plumbers and others who need a light but strong article of the kind for carrying around to different jobs. The patent eccentric pipe grip used in these vises is particularly noticeable, as

**COMBINATION MACHINIST AND PIPE VISE.**

It is something entirely new applied to a vise, and is guaranteed to absolutely never slip. These vises for a short time were made with narrow eccentrics, and in a few cases have been known to crush the pipe in disconnecting a badly-rusted joint, or cutting with very dull dies, but the manufacturers have recently materially improved the goods in every respect and especially in the eccentric grip. Instead of the narrow one formerly used they now use one that extends the full width of the jaw on each vise (see cut); and they now positively guarantee them to be absolutely non crushing as well as never slipping.

These goods are made in the same careful manner as the Rapid vises made by this concern and have a number of the same excellent features, viz: Steel

**ALL-STEEL OPEN PIPE VISE.**

bars, interchangeable steel jaws, hardened bearings in sliding jaw, steel screws, steel handles and steel eccentrics with malleable iron backs, and are guaranteed to stand any test of work within their capacity, or money refunded.

The sliding bars being of steel are much stronger than the common cast iron ones, and being much narrower give more capacity for holding pieces in a perpendicular position.

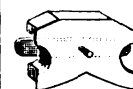
The all-steel, open pipe vise as here shown is drop-forged in one piece from bar steel, and is so proportioned that although it is by far the lightest open pipe vise made, the manufacturers guarantee that they will neither spring nor break by any use for which they are designed.

For catalogues and prices; address the manufacturers.

### Bonney's New Grip Lathe Dog.

We illustrate herewith Mr. P. S. Bonney's new "Death Grip" (as he terms it) lathe dog, which is now being manufactured by the Bonney Rapid Vise Company, Marion, Ind., and for which a patent is now pending. The advantages claimed for it are: First, no breaking, bending or bruising of screws; second, having the oscillating-toothed eccentric the same as in their patent pipe vises (see page 29, this issue), they cannot slip; third, one will take the place of at least

TRADE MARK.



EXTRA JAW.

three ordinary dogs, and with the extra smooth jaw for holding finished work (see Fig. 2) the capacity is doubled, making six or more dogs in one. Like all other goods made by this concern, they are guaranteed to give entire satisfaction, or may be returned. The following is a comical extract from one of their recent circulars:

"We are now offering three to one, with no takers, that one of our dogs, though quite young—none over six months old—can strangle any other dog, of any age, size, pedigree, color, or previous condition, in America, in just 2½ minutes, standard time. We give the following guarantee with each dog or pup, written in lathe dog blood: 'That when he sets his teeth into anything he will never let loose of his own accord, and the use of cayenne pepper, turpentine or even a club will not induce him to break his death grip, but only cause him to attack his enemy with increased fury; neither can his jaws be pried apart with an iron bar, and the only way ever yet found to break his hold on anything is to put some kind of a wrench on his head and twist his neck.' The above are doggone facts, and we have no hesitation in stating for the benefit of all lathe dog fanciers, and with no fear of contradiction, that we have the only breed of dogs, in this country at least, that always wins for their master, notwithstanding our sympathies for the under dog."

For additional particulars address the manufacturers.